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D119-796-035
Job Sheet 181780



Part No: D119-796-035

Job Qty: 1 ea

Part Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-on Landing Wearplates, Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/8/18

Job Tracking No:

Due Date: 10/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D119-796-035 REV B, IIN-D119-796 REV F IPP REV:A NEW ISSUE 15-05-13 JLM VERIFIED BY:DD
IPP REV:B 15.08.25 AS PER ECN15-580 DD VERF:JLM IPP REV:C 18.03.22 ADDED D5449-1 DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/11/18	10/11/18	0.00	0.00	Start Up Stores/Pkg-1		50
100	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging1-1		50
110	HandFinish	1 pcs	10/11/18	10/11/18	0.00	0.00	HandFinish4		JAS
120	QC	1 pcs	10/11/18	10/11/18	0.00	0.00	QC5		38
125	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging1-1		4.89
127	QC	1 pcs	10/11/18	10/11/18	0.00	0.00	QC4		N/A
130	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging3-1		50
140	QC21-FG	1 Ea	10/11/18	10/11/18	0.00	0.00	QC21		50

Part Op 100 - Photocopy bluefile and create labels as per PPP D119-796-035 chg 004/ D119-646-243 paperwork
Descriptions: 110 - ASSEMBLE AS PER DWG AND NOTES 8,9,10,11 ASSEMBLE WITH PROSEAL BATCH 5096394-INSTALL
DECAL D2729-4

130 - Identify and pack for shipping as per PPP D119-796-035 Location: _____ PPP Rev: _____

Proseal DOE: 03/19.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	8 Ea (8 ea)	90-Start up Operation	5024836
AN3C50A	Bolt	16 Ea (16 ea)	90-Start up Operation	50820618 509375017
AN4C6A	Bolt	24 Ea (24 ea)	90-Start up Operation	5076002
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	2 Ea (2 ea)	90-Start up Operation	5106182 5106198
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5116562
D119-796-251	Aft Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5116545
D2652	Bushing	48 Ea (48 ea)	90-Start up Operation	50768224 511678124
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	5104497
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	50878101

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																												
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval ☐																																												
Description Work Order Deviation		Disposi																																														
		Container No: S116574 Part: D119-796-035 Job No: 181780 Serial No/Batch: S116574 Revision: B / F Inspector: _____ Exp Date: _____ Instructions: TC STC SH14-45 - Issued, FAA STC SR0350.																																														
		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																														
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D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	5079385
D3672-3	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5027022
D3672-7	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5157448
D3883-1	Saddle, Outboard LH	2 Ea (2 ea)	90-Start up Operation	5101876
D3883-2	Saddle, Outside RH	2 Ea (2 ea)	90-Start up Operation	5102701
D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	5103378
D3884-2	Saddle, Inside RH	2 Ea (2 ea)	90-Start up Operation	5104416
D3886-041	Lug Assembly	4 Ea (4 ea)	90-Start up Operation	5105220
MS21043-3	Nut	24 Ea (24 ea)	90-Start up Operation	5083543
MS21043-4	Nut	26 Ea (26 ea)	90-Start up Operation	508927715 - 5092680 x11
MS21043-5	Nut	8 Ea (8 ea)	90-Start up Operation	5083541
MS21250-05048	Bolt (Use Ms21250-05-048)	8 Ea (8 ea)	90-Start up Operation	5093780
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation	5104354
NAS1149C0432R	Washer	48 Ea (48 ea)	90-Start up Operation	5050052
NAS1149C0532R	Washer	16 Ea (16 ea)	90-Start up Operation	5089242
D5449-1	Float Saddle Washer	4 Ea (4 ea)	90-Start up Operation	5103389
MS21920-28	Clamp	2 Ea (2 ea)	125-Packaging	5167136

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C46A	8	185	0
	AN3C50A	16	239	0
	AN4C6A	24	341	0
	D119-646-243	2	6	0
	D119-796-151	1	2	0
	D119-796-251	1	2	0
	D2652	48	681	0
	D3407-041	2	5	0
	D3417-5	4	51	0
	D3456-1	2	281	0
	D3672-3	48	931	0
	D3672-7	48	427	0
	D3883-1	2	1	0
	D3883-2	2	1	0
	D3884-1	2	7	0
	D3884-2	2	10	0
	D3886-041	4	28	0
	D5449-1	4	1	0
	MS21043-3	24	1,234	0
	MS21043-4	26	1,474	0
	MS21043-5	8	238	0
	MS21250-05048	8	32	0
	NAS1149C0332R	24	4,869	0
	NAS1149C0432R	48	1,141	0
	NAS1149C0532R	16	349	0
	MS21920-28	2	43	0
125-Packaging				

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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